Work Order ID 67728

Tuesday, March 29, 2011 2:28:31 PM

Item ID: D2364 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Deck Plate, Fwd 350 Litt

Start Date: 3/29/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 4/8/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** H **Date:** 11-03-30 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2364	Rev F								
100	FLOW WATER JET	0.00				HB11-4-6			
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2364 ☐Dwg Rev: F ☐Prog Rev: F ☐2-								
2024 -063	Deburr if necessary							(7)	
110	QC2- Inspect parts off machine FAI/FAIB	0.00				HB11-4-6			
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				(47)			
QC	**Memo**	0.00							
Quality Control									

5/04/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 67728

Tuesday, March 29, 2011 2:28:31 PM

Item ID: D2364 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Deck Plate, Fwd 350 Litt

Start Date: 3/29/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 4/8/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Run Start

Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00				7			11/04/15
Small Fab	**Memo**	0.00							
Small Fab	1- counter sink holes as per dwg D2364□2- deburr if necessary								
140	QC5- Inspect part completeness to step on W/O	0.00							11/04/15
QC	**Memo**	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00				7			11/04/15
HandFinish	**Memo**	0.00							
Hand Finishing									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 67728

Tuesday, March 29, 2011 2:28:31 PM

Item ID: D2364 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Deck Plate, Fwd 350 Litt

Start Date: 3/29/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 4/8/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00				7	11	04	19 (7)
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 830 ☐OVEN TEMPERATURE: 320° 900 ☐FINISH TIME:								
170	QC3- Inspect Part Finish	0.00				7	Ø	11/04/19	
QC	**Memo**	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: ST-225	0.00				7	JBC	11/04/19	
Packaging	**Memo**	0.00							
Packaging									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 67728

Tuesday, March 29, 2011 2:28:31 PM

Item ID: D2364 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Deck Plate, Fwd 350 Litt

Start Date: 3/29/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 4/8/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00						11/4/20	
QC	**Memo**	0.00							
Quality Control									

11-04-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 2:28:37 PM

Work Order ID: 67728

Parent Item: D2364

Parent Item Name: Deck Plate, Fwd 350 Litt

Start Date: 3/29/2011 **Required Date:** 4/8/2011

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP REV. E□00.06.26□Removed P/O for powder coat□EC□
IPP Rev:F Now On Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	57.0000	0.6469	4.085684	4.6		

2024-T3 .063 sheet

HB11-4-6

Location	Loc Qty	Loc Code
MAT022	57	
113867	5	
114351	4	
117018	48	

114351

(7)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	67738
Description: Litter Deck Plate Kit (350)	Part Number:	D2364
Inspection Dwg: D2364 **Rev:** F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.624	✓		V HB02	
Ø0.171	+0.005/-0.000	.172	✓		V	
0.354	+/-0.010	.356	✓		V	
11.242	+/-0.010	11.246	✓		PROW302	
3.031	+/-0.010	3.035	✓		V	
1.903	+/-0.010	1.903	✓		V	
1.128	+/-0.010	1.126	✓		V	
0.354	+/-0.010	.354	✓		V	
1.340	+/-0.005	1.338	✓		V	
2.326	+/-0.010	2.324	✓		V	
3.312	+/-0.010	3.309	✓		V	
4.298	+/-0.010	4.298	✓		V	
5.284	+/-0.010	5.284	✓		V	
6.151	+/-0.010	6.151	✓		V	
6.270	+/-0.010	6.270	✓		V	
0.354	+/-0.010	.353	✓		V	
3.031	+/-0.010	3.036	✓		V	
Ø0.656	+0.005/-0.000	.657	✓		V	
5.003	+/-0.010	5.003	✓		V	
4.605	+/-0.010	4.601	✓		V	
1.776	+/-0.010	1.774	✓		V	
0.980	+/-0.010	.977	✓		V	
4.487	+/-0.010	4.487	✓		V	
7.192	+/-0.010	7.190	✓		V	
7.567	+/-0.010	7.565	✓		V	
7.942	+/-0.010	7.945	✓		V	
Ø0.191	+0.005/-0.000	.191	✓		V	
Ø0.197	+0.005/-0.000	.197	✓		V	
11.145	+/-0.010	11.145	✓		P	
12.181	+/-0.010	12.181	✓		T HB01	
11.378	+/-0.010	11.378	✓		P	
11.776	+/-0.010	11.776	✓		P	
12.173	+/-0.010	12.173	✓		T	
4.690	+/-0.010	4.691	✓		V	
Ø 0.250	+0.005/-0.000	.250	✓		V	
3.141	+/-0.010	3.144	✓		V	
Ø 0.171	+0.005/-0.000	.171	✓		V	

Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	11-4-6	Date:	11/04/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67228

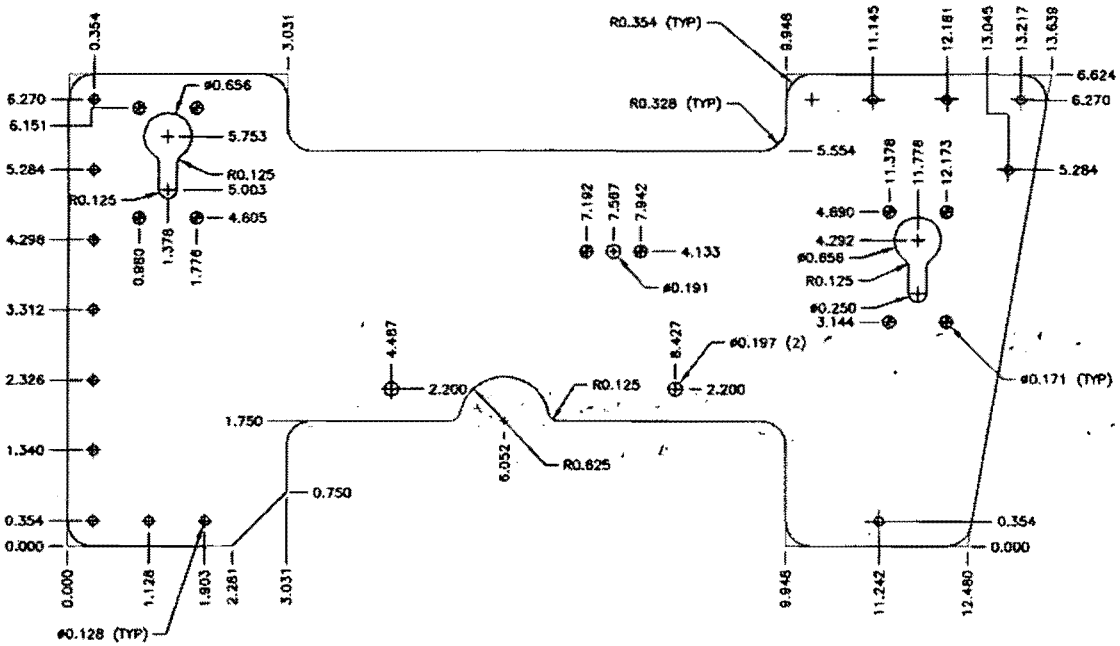
99/11-03-30

RELEASED
99/06/22 KE

DART

QA COPY ISSUED

COUNTER SINK HOLES:
◆ C'SINK Ø0.225 x 100° (UPDATED FROM 9 TO 14 HOLES BY DS 99.03.01 TO CORRECT CAD ERROR)
⊕ C'SINK Ø0.308 x 100°



MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	
E	95.10.06	GEOMETRY CHANGES	
D	95.03.06	0.191 WAS 0.197	
B	95.02.09	MOVED KEYWAY	
A	95.01.14	NEW ISSUE	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. F
CHECKED	APPROVED	DRAWING NO. D2364	SHEET 1 OF 1
DATE 98.06.19		TITLE LITTER DECK PLATE, 350	SCALE 2:5

Copyright 1995 by DART AEROSPACE LTD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries